

Date: Monday, 18/08/2008 3:41:01 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	LITTER TIE DOWN ASS'Y
Job Number :	41337		
Estimate Number :	10360		
P.O. Number :		Part Number :	D2350
This Issue :	18/08/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2350 / D2363
First Issue :	/ /	Project Number :	N/A
Previous Run :	39221	Drawing Revision :	B / F
Written By :		Material :	
Checked & Approved By :	<u>JLD 08.8.18</u>	Due Date :	10/09/2008
Comment :	est rev B 06.05.17 added ass'y EC Est Rev:C 08-05-13 chg to revF DD verified by:EC		

Qty: 6 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6201	"T" Extrusion
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Comment: Qty.: 1.0631 f(s)/Unit Total: 6.3788 f(s)

Material: D6201 (6061-T6 (QQ-A-200/8) 4" x 4" x 3/8" Thick 'T' extrusion

D36793

Batch:

ML 08/09/14

(6)

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blanks: 12.150" long

ML 08/09/14

(6)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio D2363 and Dwg D2363

Debur

N.A

08/09/14

(6)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

N.A

08/09/14

(6)

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

ML 08/09/14

(6)

6.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

Tumble & deburr

N/A

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 3:41:01 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y

Job Number: 41337

Part Number: D2350

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

OK

CE

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M.H.

08/09/16

6x

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 7:15 AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 7:45 AM

H

08-09-17

x6

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/09/18

6

11.0

D2372

Quick Release



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2372

Fastener

39456 x10

B41426

08/09/17

2x

12.0

D2444

Pip Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2444

Pip Pin

41429 x5

B38895 x1

08/09/17

13.0

AN960JD10L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

3 AN960JD10L

Washer

M105793

08/09/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 3:41:01 PM
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Process Sheet

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Drawing Name: LITTER TIE DOWN ASS'Y

Job Number: 41337

Part Number: D2350

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

MS21042L3

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 MS21042L3 Nut (or -3)

M108701

JS 08/09/17 @

15.0

MS27039113

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS27039-1-13 Screw

10524

JS 08/09/17 @

16.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D2350

JS 08/09/18 @

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JS 08/09/18 @

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 185

8/9/18

X6

SD

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/19 JS

Job Completion



MF 08-09-19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

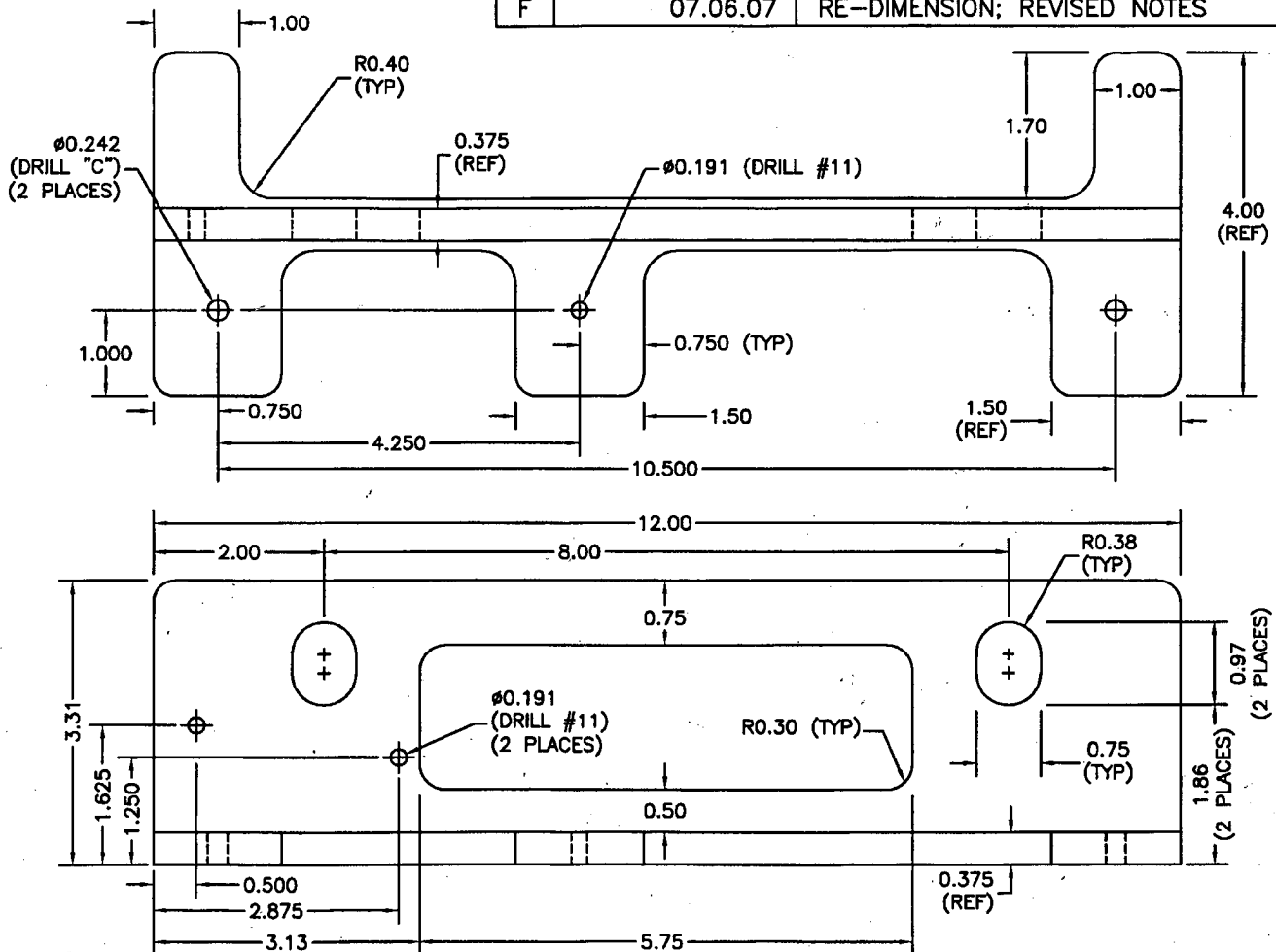
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN BW	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D2363	REV. F SHEET 1 OF 1
DATE 07.06.07		TITLE LITTER TIE DOWN BRACKET	SCALE 1:2
A	95.01.14	NEW ISSUE	
B	95.02.14	MODIFIED HOLES	
C	95.03.06	0.191 WAS 0.197	
D	95.03.06	CHANGES TO DIMENSIONS	
E	97.10.01	CHANGES FOR MACHINING	
F	07.06.07	RE-DIMENSION; REVISED NOTES	

**D2363 LITTER TIE DOWN BRACKET**

- 1) MATERIAL: MAKE FROM D6201-012 EXTRUSION (6061-T6/T651 PER QQ-A-200/8)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N "D2363" USING FINE POINT PERMANENT INK MARKER

RELEASED

07.06.22



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WORK ORDER

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2248

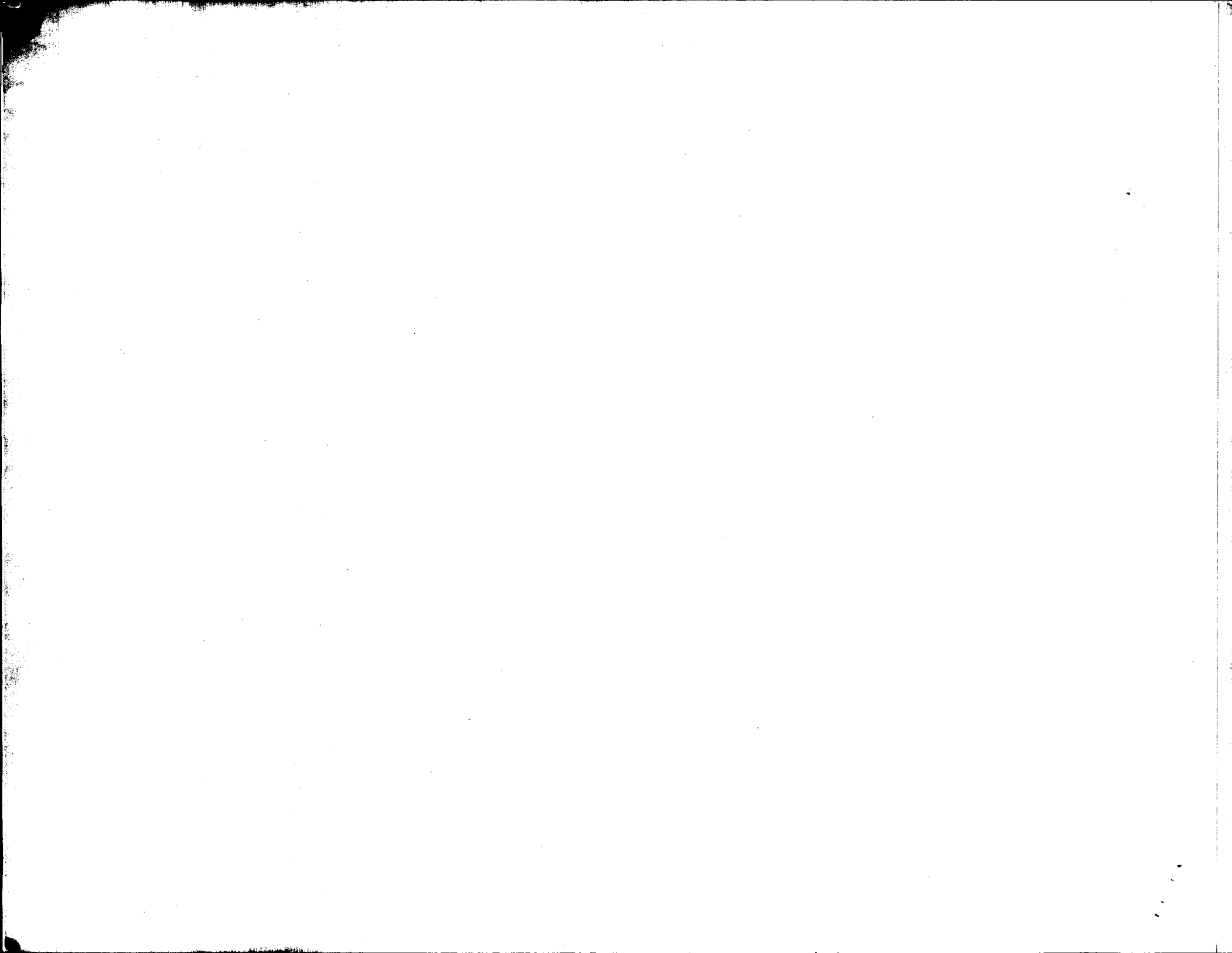


DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED BW	APPROVED [Signature]	D2350	SHEET 1 OF 2
DATE 95:02:20	TITLE LITTER TIE DOWN ASSEMBLY		SCALE

RELEASED
960607

D2350	Part No.	Description
X	D2350	LITTER TIE DOWN ASSEMBLY (NON-LOCKING)
1	D2363	LITTER TIE DOWN (NON-LOCKING)
2	D2372	QUICK RELEASE FASTENER
1	D2444	PIP PIN
KE 99.04.29 X 3	AD960JD10 L	WASHER
1	MS21042L3	NUT
1	MS27039-A-13	SCREW

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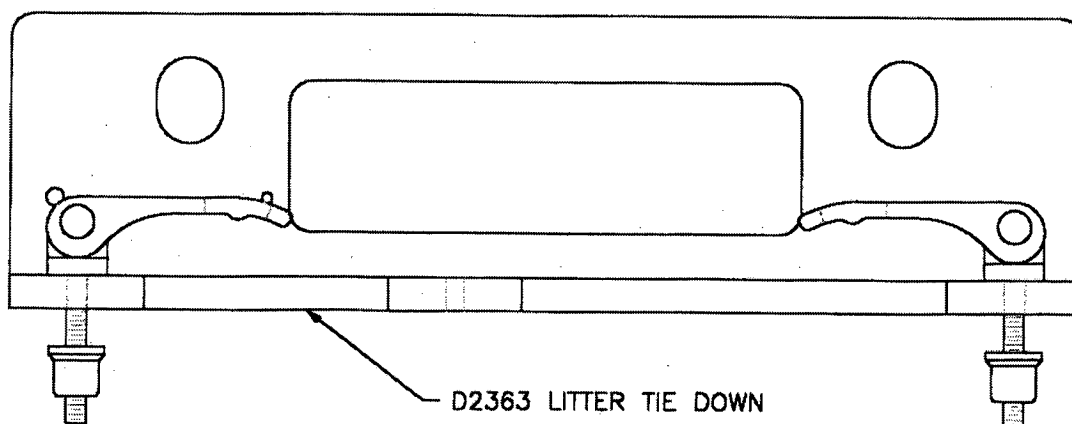
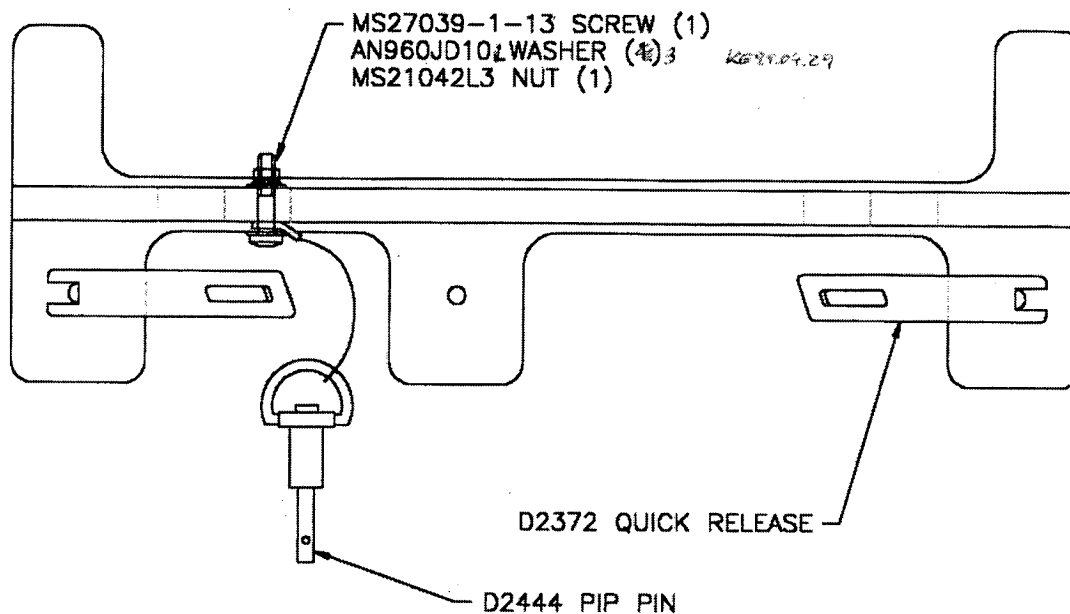


DART



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B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED	APPROVED	D2350	SHEET 2 OF 2
DATE		TITLE	SCALE
95:02:20		LITTER TIE DOWN ASSEMBLY	

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960607



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